

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER :									

Work Order ID 146883

Tuesday, May 24, 2016 9:59:16 AM

146883

Page 2

Item ID: D412-711-101

Accept

N900040100Setup Start ***NS1***

Revision ID: URF 16-559

Stop ***NS2***

Item Name: Replacement Vertical Reference Window

Start Date: 5/17/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							DAS 07 9-89
130	THERMOFORMING MACHINE								
Thermoform	Memo	1.26				x2			16/06/03
Thermoforming Machine	Thermoform as per Dwg. D412-711-101 using DT 9640 and Folio FTA 077								
	Dwg. Rev. <u>B</u>								
	Folio Rev. <u>C</u>								
	Visually inspect for proper formation and clarity								
	Visually and inspect magic eye								
	Verified by: <u>Ph</u>								
160		0.00							DAS 07 9-89
160	HAND FINISHING THERMOFORMING								
HandThermo	Memo	2.38				x2			16/06/03
Hand Finishing Thermoforming	1) Trim off excess flange material 2) Buff out any light scratches or 3) Etch part number and batch number								

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Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

1 4688.3

Tuesday, May 24, 2016 9:59:16 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Replacement Vertical Reference Window

Start Date: 5/17/2016 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 5/24/2016 **Req'd Qty:** 2.00 ***2***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NB2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

190

Identify as per dwg & Stock Location:_____

0.00

190

Packaging

Memo

Location : FG099

0.00
PPP 147102 1x
0.02
PKIS x1

27 SmB
16/6/2

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.20

Quality Control

MCS JUN 03 2016

mlj JUN 03 2016

DQA: _____ Date: _____



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Work Order update only ☐

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Picklist Print

Tuesday, May 24, 2016 9:59:15 AM

Page 1

Work Order ID: 146883

146883

Parent Item: D412-711-101

D412-711-101

Parent Item Name: Replacement Vertical Reference Window

Start Date: 5/17/2016

Required Date: 5/24/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-02-01 JLM
Manufacture in-house 10/06/28 DL

IPP Rev. B.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.236		Purchased	No				sf	468.2500		42.66667			DAS 07 9-89

MACRI ICS 236

Plexiglass G 0.236"

10/06/03

Location

Loc Qty

Loc Code

therm

468.2500333

M132743

22.0000333

M134281

16

M134582

64

M134641

160

M134733

206.25

32 sg PL.

DQA: _____ Date: _____

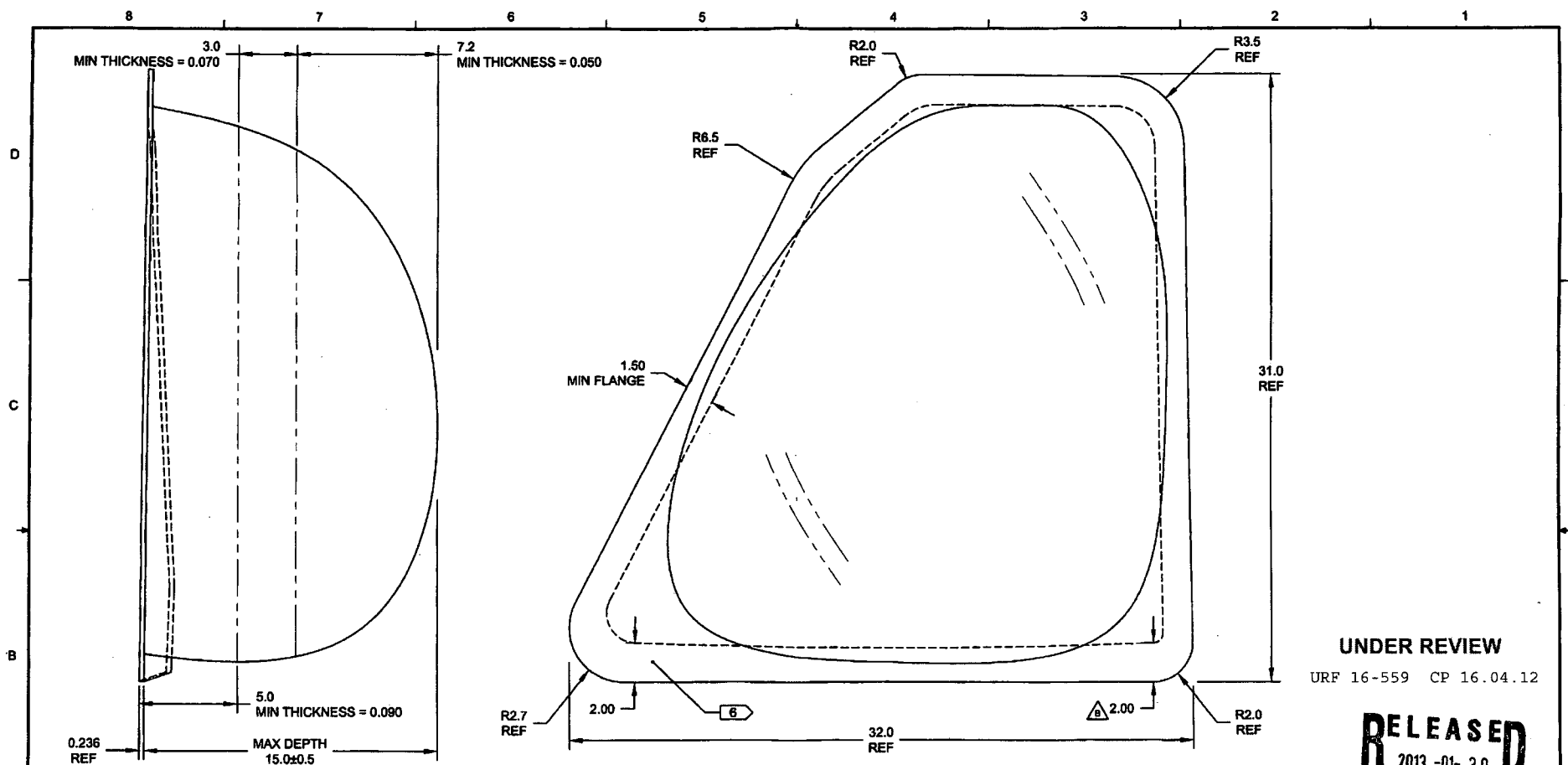


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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



UNDER REVIEW

URF 16-559 CP 16.04.12

RELEASED
2013-01-30

D412-711-101 REPLACEMENT WINDOW

NOTES:

1) MATERIAL: PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C
OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425,
0.236 THICK (STOCK, REF. DART SPEC. M-ACRYLIC-S.236)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: ENGRAVE P/N "D412-711-101" & B/N "BXXXXX" ON THE INSIDE SURFACE
OF THE BUBBLE WINDOW FLANGE, WITHIN 0.25" OF BUBBLE. USE 0.125" LETTERS TO MAX. DEPTH OF 0.005"

7) WEIGHT: 8.0 lbs

8) VACUUM FORMING: PER FOLIO FTA077 USING DT9640 MOLD AND DART QSI 022

B	REMOVED 1.73" DIM (ZN B4-1). SEE PREVIOUS REV. FOR DETAILS. 2.00 WAS 1.98 (ZN B3-1) REF CIR12-8	SFM	12.12.24
A	NEW ISSUE	MB	10.08.28
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	SFM		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.12.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D412-711-101

REV. B
SHEET 1 OF 1

TITLE
REPLACEMENT WINDOW

SCALE
NTS

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NO. 146883 MLJ
160525

DART AEROSPACE LTD		Work Order:	146803
Description: Replacement Window		Part Number:	D412-711-101
Inspection Dwg: D412-711-101 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

DAS

Measured by:

07
9-89

Date:

16/06/03

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	+/-0.030	<u>2.00</u> "	✓			
<u>1.98</u> <u>N/A</u>	+/-0.030					
1.50	Min	<u>1.56</u> "	✓			
0.090	Min	<u>0.098</u> "	✓			
0.070	Min	<u>0.094</u> "	✓			
0.050	Min	<u>0.076</u> "	✓			
15.0	+/-0.5	<u>15.0</u> "	✓			

DAS

Measured by:

07
9-89

Date:

16/06/03

Audited by:

AD

Date:

16-06-03.

Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
B	10.10.08	New Issue	KJ	
C	13.06.03	Dimensions updated per Dwg Rev B	KJ <u> </u>	<u> </u>